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मानक

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IS 747 (1991): Handloom Cotton Bunting Cloth, Dyed [TXD 8: Handloom and Khadi]



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“Knowledge is such a treasure which cannot be stolen”

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भारतीय मानक

हथकरघा निर्मित सूती बंटिंग कपड़ा, रंजित—विशिष्ट
(दूसरा पुनरीक्षण)

Indian Standard

HANDLOOM COTTON BUNTING CLOTH,
DYED—SPECIFICATION

(Second Revision)

UDC 677·21·074

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BUREAU OF INDIAN STANDARDS
MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG
NEW DELHI 110002

FOREWORD

This Indian Standard (Second Revision) was adopted by the Bureau of Indian Standards, after the draft finalized by the Handloom and Khadi Sectional Committee had been approved by the Textile Division Council.

This standard was first published in 1955 and subsequently revised in 1982. This standard has been again revised in order to overcome certain difficulties encountered by the handloom industry in implementation of this standard.

Following are the important changes carried out while revising this standard:

- a) Use of cotton yarn conforming to IS 171: 1985 'Cotton and cotton regenerated cellulosic fibre blended gray yarn (*third revision*)' has been specified.
- b) Only negative tolerances have been specified on ends/dm, picks/dm and mass g/m² to ensure minimum desirable construction. There being no tolerance on positive side of these requirements, it would provide flexibility to industry to adjust construction of the fabrics depending upon market demands.
- c) Breaking load requirement has been specified as optional requirement. This requirement has to be enforced in case it is not possible to establish that cotton yarn conforming to IS 171 : 1985 has been used.
- d) Tolerances on length and width have been adopted from the instructions issued by the Central Government under Trade and Merchandise Marks Act 1958 (43 of 1958) as given in Notification No. S. O. 2937 dated 20 September 1962.
- e) For determining the conformity of the cloth to the requirements laid down in this standard, a provision has been incorporated to allow testing of specimens in prevailing atmospheric conditions. However, in all cases of disputes specimens shall be tested after conditioning in the standard atmospheric conditions.
- f) Provision has been incorporated for agreement between the buyer and the seller with respect to permissible number of defects in the cloth.

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 1960 'Rules for rounding off numerical values (*revised*)'. The number of significant places retained in the round off value should be the same as that of the specified value in this standard.

Indian Standard

HANDLOOM COTTON BUNTING CLOTH, DYED — SPECIFICATION

(Second Revision)

1 SCOPE

1.1 This standard prescribes constructional particulars and other requirements for three varieties of handloom cotton bunting cloth, dyed.

1.2 This standard does not specify the general appearance, feel, finish, etc.

2 REFERENCES

2.1 The Indian Standards listed at Annex A are necessary adjuncts to this standard.

3 ATMOSPHERIC CONDITIONS FOR TESTING

3.1 Test specimens may be conditioned and tested in the prevailing atmosphere for determining the conformity of the cloth to this standard. However, in all cases of disputes, specimens shall be conditioned and tested in the standard atmosphere as specified in the referred Indian Standards on test methods.

4 YARN

4.1 The cotton yarn used shall conform to the requirements specified in IS 171 : 1985.

5 REQUIREMENTS

5.1 The bunting cloth shall conform to the requirements specified in Table 1.

5.1.1 However, breaking load requirement shall be optional. It shall be enforced only when conformity of cotton yarn to the requirements specified in IS 171 : 1985 is not known.

5.2 The bunting cloth shall also conform to the requirements specified in Table 2.

5.3 The bunting cloth shall be woven in plain weave.

5.4 Dimensions

Length and width of the cloth when determined in accordance with IS 1954 : 1969 shall be as agreed to between the buyer and the seller or as declared by the seller subject to the tolerances specified in the Government of India, Ministry of Commerce and Industry Notification No. S. O. 2937 dated 20 September 1962 issued under Trade and Merchandise Marks Act 1958 (43 of 1958) (see Annex B).

5.5 In order to illustrate or specify the indeterminate characteristics, such as general appearance, lustre, feel and shade, a sample shall be agreed upon and sealed, the supply shall be in conformity with the sample in such respects.

**Table 1 Constructional Particulars and Breaking Load Requirements
for Handloom Cotton Bunting Cloth, Dyed**
(Clause 5.1)

Variety No.	Count of Yarn* Universal Count (Cotton Count)		Ends/dm	Picks/dm	Mass g/m ²	Breaking Load in Newton	
	Warp	Weft				Warp	Weft
1	60 tex × 2 (10s/2)	60 tex (10s)	110	140	230	400	200
2	30 tex × 2 (20s/2)	30 tex × 2 (20s/2)	160	170	205	460	480
3	30 tex × 2 (20s/2)	30 tex × 2 (20s/2)	180	180	230	480	480
Tolerance percent	—	—	—5	—5	—5	—5 on average value and —15 on individual reading	
Method of test	—	—	IS 1963 : 1981		IS 1964 : 1970 or Annex D	IS 1969 : 1985	

*For guidance only.

Table 2 Other Requirements for Handloom Cotton Bunting Cloth, Dyed
(Clause 5.2)

Sl No.	Characteristics	Requirement	Method of Test, Ref to
(1)	(2)	(3)	(4)
i)	Dimensional change, percent, <i>Max</i>	4	IS 2977 : 1989
ii)	Scouring loss percent, <i>Max</i>	2.5	IS 1383 : 1977
iii)	pH value of the aqueous extract	6.0 to 8.5	IS 1390 : 1983
iv)	Colour fastness :		
	a) Light	5 or better	IS 686 : 1985 or IS 2454 : 1985
	b) Washing : Test 1		IS 687 : 1979
	1) Change in colour	4 or better	
	2) Staining on fabric	4 or better	

5.5.1 The custody of the sealed sample shall be a matter of prior agreement between the buyer and the seller.

6 INSPECTION

6.1 The bunting cloth when visually inspected should be free from the major flaws listed at Annex C.

6.1.1 The number of permissible major flaws per unit length in the cloth shall be as agreed to between the buyer and the seller.

6.2 For details of the flaws mentioned in 6.1, a reference may be made to IS 4125 : 1987.

7 MARKING

7.1 The bunting cloth shall be suitably marked with the following information:

- Name of the material and variety No.,
- Length (m) and width (cm), and
- Indication of the source of manufacture.

7.1.1 The bunting cloth may also be marked with the Standard Mark, details which may be obtained from the Bureau of Indian Standards.

8 PACKING

8.1 Unless otherwise agreed upon by the buyer and the seller the cloth shall be preferably packed in bales or cases in conformity with the procedure laid down in IS 1347 : 1972 or IS 293 : 1980.

9 SAMPLING

9.1 Lot

The quantity of the bunting cloth of the same variety delivered to one buyer against one despatch note shall constitute a lot.

9.2 The conformity of the lot to the various requirements specified in the standard shall be determined on the basis of tests carried out on the samples selected from the lot.

9.3 Unless otherwise agreed, the number of pieces selected at random for inspection shall be in accordance with the Table 3.

Table 3 Sample Size and Permissible Number of Non-Conforming Pieces

Lot Size	Sample Size	Permissible Number of Non-conforming Pieces	Sub-sample Size
(1)	(2)	(3)	(4)
Up to 25	3	0	2
26 „ 50	5	0	2
51 „ 150	8	0	3
151 „ 300	13	1	3
301 „ 500	20	1	5
501 „ 1 000	32	2	5
1 001 and above	50	3	8

9.3.1 For selection of samples at random from the lot, procedure given in IS 4905 : 1968 may be followed.

9.4 Number of Samples and Criteria for Conformity

It shall be as follows:

Characteristics	Number of Samples	Criteria for Conformity
Ends, picks, mass, length, width and visual inspection	According to col 2 of Table 3	Number of non-conforming pieces shall not exceed the corresponding number given in col 3
Dimensional change, colour fastness, scouring loss, pH value and breaking load	According to col 4 of Table 3	All the test pieces shall meet the requirement

ANNEX A

(Clause 2.1)

LIST OF REFERRED INDIAN STANDARDS

IS No.	Title	IS No.	Title
293 : 1980	Code for seaworthy packaging of cotton yarn and cloth (<i>third revision</i>)	1963 : 1981	Methods for determination of threads per unit length in woven fabrics (<i>second revision</i>)
686 : 1985	Methods for determination of colour fastness of textile materials to daylight (<i>first revision</i>)	1964 : 1970	Methods for determination of weight per square metre and weight per linear metre of fabrics (<i>first revision</i>)
687 : 1979	Methods for determination of colour fastness of textile materials to washing : Test 1 (<i>second revision</i>)	1969 : 1985	Methods for determination of breaking load and elongation of woven textile fabrics (<i>second revision</i>)
1347 : 1972	Inland packaging of cotton cloth and yarn (<i>first revision</i>)	2454 : 1985	Methods for determination of colour fastness of textile materials to artificial light (xenon lamp) (<i>first revision</i>)
1383 : 1977	Methods for determination of scouring loss in grey and finished cotton textile materials (<i>first revision</i>)	2977 : 1989	Methods for determination of dimensional changes of woven fabrics (other than wool) on soaking in water (<i>first revision</i>)
1390 : 1983	Methods for determination of pH value of aqueous extracts of textile materials (<i>first revision</i>)	4125 : 1987	Glossary of terms pertaining to defects in fabrics (<i>first revision</i>)
1954 : 1969	Methods for determination of length and width of fabrics (<i>first revision</i>)	4905 : 1968	Methods for random sampling

ANNEX B

(Clause 5.4)

EXTRACTS FROM THE GOVERNMENT OF INDIA, MINISTRY OF COMMERCE AND INDUSTRY (TRADE AND MERCHANDISE MARKS) NOTIFICATION NO. S. O. 2937, DATED 20 SEPTEMBER 1962

1. A trade description of length stamped on grey, bleached, mercerised or coloured cotton piece goods:

- i) in pieces stamped as of length 9 metres and below the stamped length shall not exceed the actual length by more than 1 percent of the piece length or 7.5 cm whichever is less, and;
- ii) in pieces stamped as of length above 9 metres the stamped lengths shall not exceed the actual length by more than 0.6 percent of the piece length or 7.5 cm whichever is higher.

Provided that the average length of the pieces in question shall not be less than the stamped length.

2. A Trade description of width stamped on grey, bleached, mercerised or coloured cotton

piece goods:

- i) in pieces stamped as of width 102 cm or below, the stamped width shall not exceed the actual width at any point by more than 1.3 cm;
- ii) in pieces stamped as of width over 102 cm upto 152 cm the stamped width shall not exceed the actual width at any point by more than 1.25 percent of the stamped width of the piece;
- iii) in pieces stamped as of width 152 cm and above the stamped width shall not exceed the actual width at any point by more than 1.25 percent of the stamped width of the piece or 2.5 cm whichever is less.

Provided that average width of the piece in question shall not be less than the stamped width.

ANNEX C

(*Clause 8.1*)

LIST OF MAJOR FLAWS

One or more ends missing in the body of the material throughout its length, more than three ends missing at a place and running over 60 cm, or prominently noticeable double end running throughout the piece.

Undressed snarls noticeable over a length exceeding 5 percent of the length of the piece.

Smash definitely rupturing the texture of the fabric.

Hole, cut or tear.

Reed marks prominently noticeable over a length exceeding 5 percent of the piece.

Defective or damaged selvage noticeable over a length exceeding 5 percent of the length of the piece.

Skewing of more than three percent on weft.

Weft crack or two or more missing picks across the width of the fabric.

Warp or weft bar due to the difference in raw material, count twist, lustre, colour, shade or spacing of adjacent groups of yarns (starting mark).

More than two adjacent ends running parallel, broken or missing and extending beyond 10 cm. Noticeable warp or weft float in the body of the fabric.

Noticeable oil or other stain in the fabric.

Oily weft in the fabric.

Prominently noticeable slub.

Conspicuous broken pattern.

Gout due to foreign matter, usually lint or waste woven into the fabric.

Prominent selvage defect.

Significant shading or listing in fabric having a gradual change in tone or depth of shade of fabric (excluding selvage or border running parallel to the selvage).

Coloured flecks.

Blurred or dark patch.

Patchy, streaky or uneven dyeing.

Dye bar.

Fuzzy appearance.

ANNEX D

(*Table 1*)

METHOD FOR DETERMINATION OF MASS OF FABRIC

D-1 Cut four specimens of 100 mm × 100 mm from a sample. Condition all the specimens in the dessicator charged with saturated solution of sodium nitrate at $27 \pm 2^\circ \text{C}$ for a period of 24 hours. Remove all the specimens from the

dessicator and immediately determine their collective mass in weighing balance to the nearest miligram.

D-2 Calculate mass of fabric in g/m².

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